

Work Order ID 52624

October 5, 2009 8:24:25 AM



Page 1

Item ID: D206-667-201TRN
Revision ID: C
Item Name: Crosstube Turning Detail

Accept



Setup Start



Stop



Start Date: 05/10/2009 Start Qty: 1.00

Required Date: 20/10/2009 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *BL*

Date: *09-10-5*

Tooling:

Date:

Run Start



Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D206-667-241

Rev C

100

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA084□2-Turn first side as per Folio FA084□3-File down transition lines smooth.

Q.m 09-10-08⑦

110

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

Q.m 09-10-08⑦

120

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Turn second side as per Folio FA084□2-File down transition lines smooth.
□
3-Remove sand and plugs

Q.m 09-10-08⑦

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC1- Inspect dimensions to dimension sheet 0.00



QC

Memo

0.00

Quality Control

A.M 09 - 10 - 08 ①

140 QC8- Inspect parts - second check 0.00



QC

Memo

0.00

Quality Control

1 Ø - AWM 9-10-08

150 Crosstubes Chemical Conversion 0.00



HandFXtube

Memo

0.00

Hand Finishing Crosstubes

A.M 09 - 10 - 08 ①

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October 5, 2009 8:24:25 AM



Page 3

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Setup Start
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Start Date: 05/10/2009 Start Qty: 1.00
Required Date: 20/10/2009 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo 	0.00							
170 	Packaging	0.00							
Packaging	Memo Identify and Stock in kanban rack <input type="checkbox"/> Location <u>LG</u>	0.00							
Packaging									
180 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

Am 09-10-08 ①

09/10/13
MF 09-10-08

Picklist Print

October 5, 2009 8:24:25 AM

Page 1

Work Order ID: 52624



Parent Item: D206-667-201TRNRevC



Parent Item Name: Crosstube Turning Detail

Start Date: 05/10/2009

Required Date: 20/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D6003-102RevA

Manufactured

No

110

Each

62.0000

1.0000



Q.m 09-10-08

Crosstube, 206

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

62

29116

11

38335

51

i

DART AEROSPACE LTD	Work Order:	52624
Description: Crosstube Assembly	Part Number:	D206-667-241
Inspection Dwg: D206-667-241 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	30° x 0.500	+/-0.010	30° 6500	/		
	0.250	+/-0.010	0.250	/		
	2.240	+0.005/-0.000	2.244	/		
	4.438	+/-0.030	4.438	/		
	1.780	+0.005/-0.000	1.785	/		
	R0.063	+/-0.010	R0.063	/		
	1.851	+0.005/-0.000	1.856	/		
	1.928	+0.005/-0.000	1.932	/		
	2.005	+0.005/-0.000	2.008	/		
	2.082	+0.005/-0.000	2.086	/		
	2.159	+0.005/-0.000	2.163	/		
	2.190	+0.005/-0.000	2.194	/		
SIDE B	30° x 0.500	+/-0.010	30° 40.500	/		
	0.250	+/-0.010	0.250	/		
	2.240	+0.005/-0.000	2.245	/		
	4.438	+/-0.030	4.438	/		
	1.780	+0.005/-0.000	1.785	/		
	R0.063	+/-0.010	R0.063	/		
	1.851	+0.005/-0.000	1.856	/		
	1.928	+0.005/-0.000	1.932	/		
	2.005	+0.005/-0.000	2.008	/		
	2.082	+0.005/-0.000	2.087	/		
	2.159	+0.005/-0.000	2.163	/		
	2.190	+0.005/-0.000	2.194	/		
	100.60	+/-0.020	100.620	/		

Measured by:	A.M.	Audited by:	AWM	Prototype Approval:	N/A
Date:	09.10.08	Date:	9-10-08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.16	New Issue (P/O D206-667-201)	KJ/JLM	
B	09.05.20	Dwg Rev updated	KJ	

Item	Qty -241	Part Number	Description
1	X	D206-667-241	CROSSTUBE ASSEMBLY (206B HIGH AFT)
2	1	D6003-102	CROSSTUBE
3	2	D2891-1	SUPPORT
4	4	D3595-063-395	RUBBER CUSHION
5	4	MS21920-20	CLAMP (OR MS21920-21)
6	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6003-102
FINISHED LENGTH = 100.60±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-241" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 22.5 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 12 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS MECHANISMS ARE LOCATED ON CROSSTUBE CLAMPS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

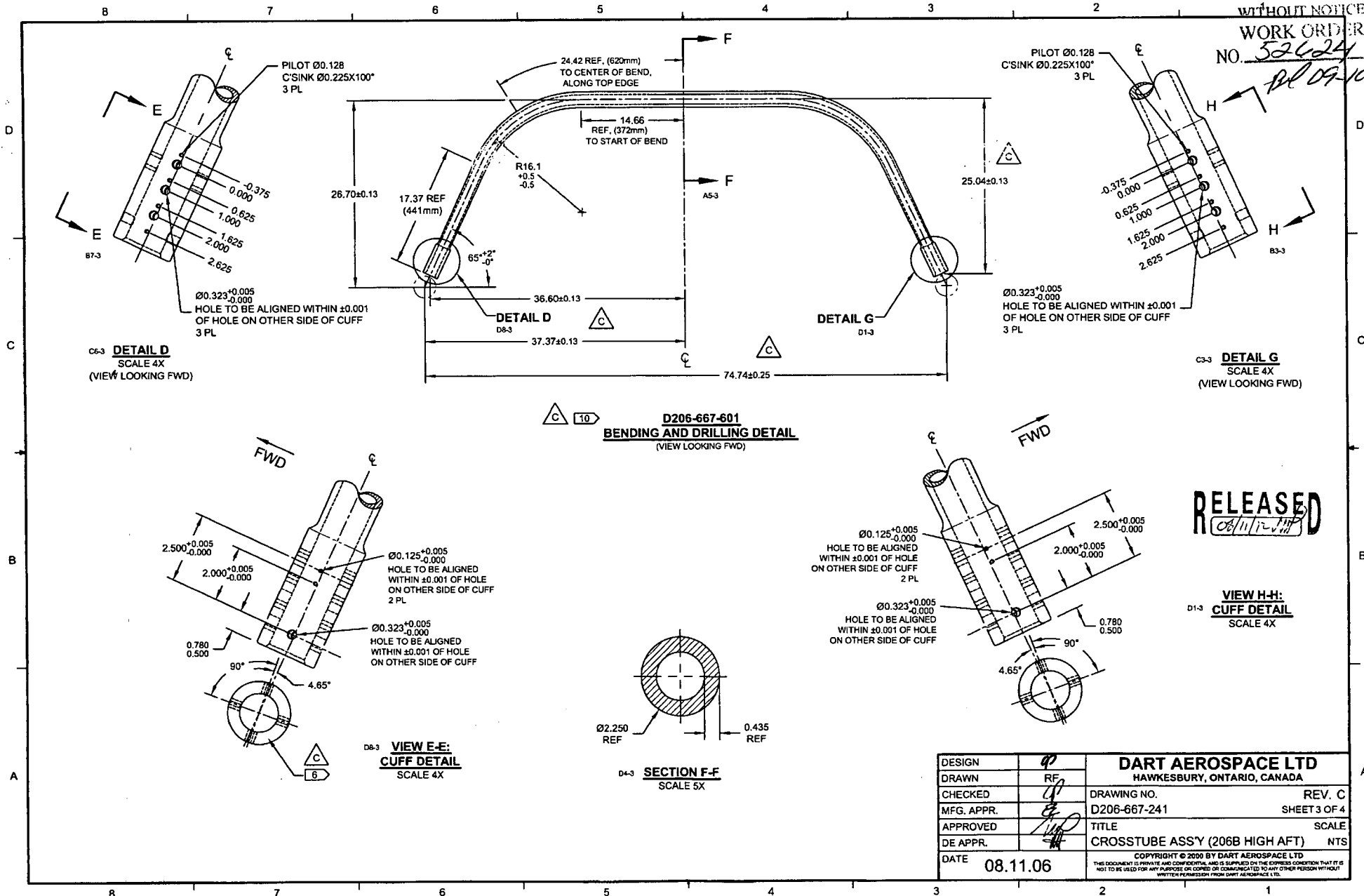
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08/11/12

C	REFORMAT/REVISE GENERAL NOTES/PART LIST (ZN 07-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCES (ZN C5-3, C4-3, D3-3); RELOCATED FLAG #6 (ZN A7-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	90	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JP	D206-667-241	SHEET 1 OF 4
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	CROSSTUBE ASSY (206B HIGH AFT)	NTS
DATE	08.11.06	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

WORK ORDER
NO. 52624

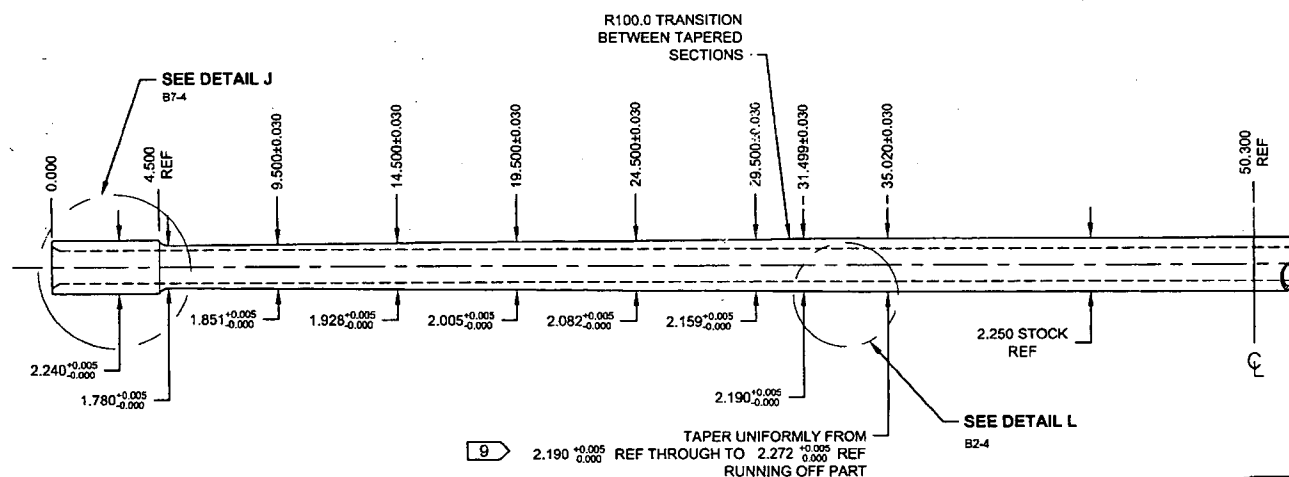
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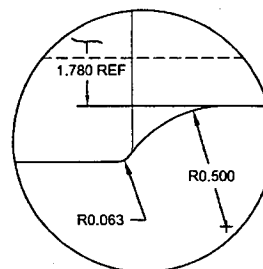
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D206-667-241	SHEET 3 OF 4
APPROVED		TITLE	SCALE
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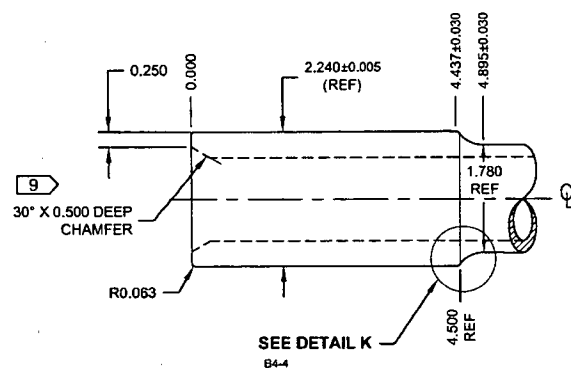
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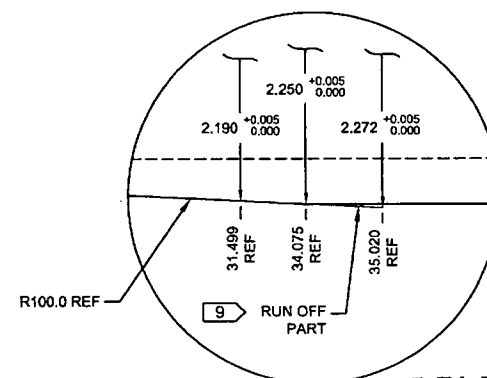
TURNING DETAIL



**DETAIL K:
CUFF TRANSITION**
NOT TO SCALE



**DETAIL J:
CROSSTUBE CUFF**
NOT TO SCALE



**DETAIL L:
TAPER RUN-OFF**
NOT TO SCALE

RELEASED
06/11/12 J.H.

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CHECKED	RF	DRAWING NO.	REV. C
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